

Date: Friday, 9/21/2007 1:17:08 PM
User: Kim Johnston

Process Sheet

split 2

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34807
Estimate Number : 12784
P.O. Number : N/A
This Issue : 9/21/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : 9/21/2007 Type : SMALL / MED FAB
Previous Run : 33804
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07-03-08 ec
Est Rev:B As per Rev C 07-07-09 JLM
Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Drawing Name : WEARPAD
Part Number : D35649
Drawing Number : D3564 REV D
Project Number : N/A
Drawing Revision : D
Material : N/A
Due Date : 10/5/2007 Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 063 Sheet



30.2841 sf



Comment: Qty.: 0.9177 sf(s)/Unit Total: 27.5310 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: 105804 B07-10-11

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3564 ***** (D3564-1F)*****
Dwg Rev: 4
Prog Rev: 8 B07-10-11

33

2-Debur if necessary B07-10-11

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B07-10-11

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



counter

Comment: SECOND CHECK

9/10/15 433

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Debur if necessary
Form on Brake as per Dwg D3564 using Jigs DT and DT

Form Joggle as per Dwg D3564 on brake using Jig DT

9/10/17 33

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Drawing Name: WEARPAD

Job Number: 34807

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/10/17 (433) counter

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

M 105544

Weld hardcoat as per Dwg D3437

FC 07 10 23 (10)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/10/23 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/23 (10) counter

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 104546

BR 07-10-24

(10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MS

07-10-24

(10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-15

MS

07-10-24

(10)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



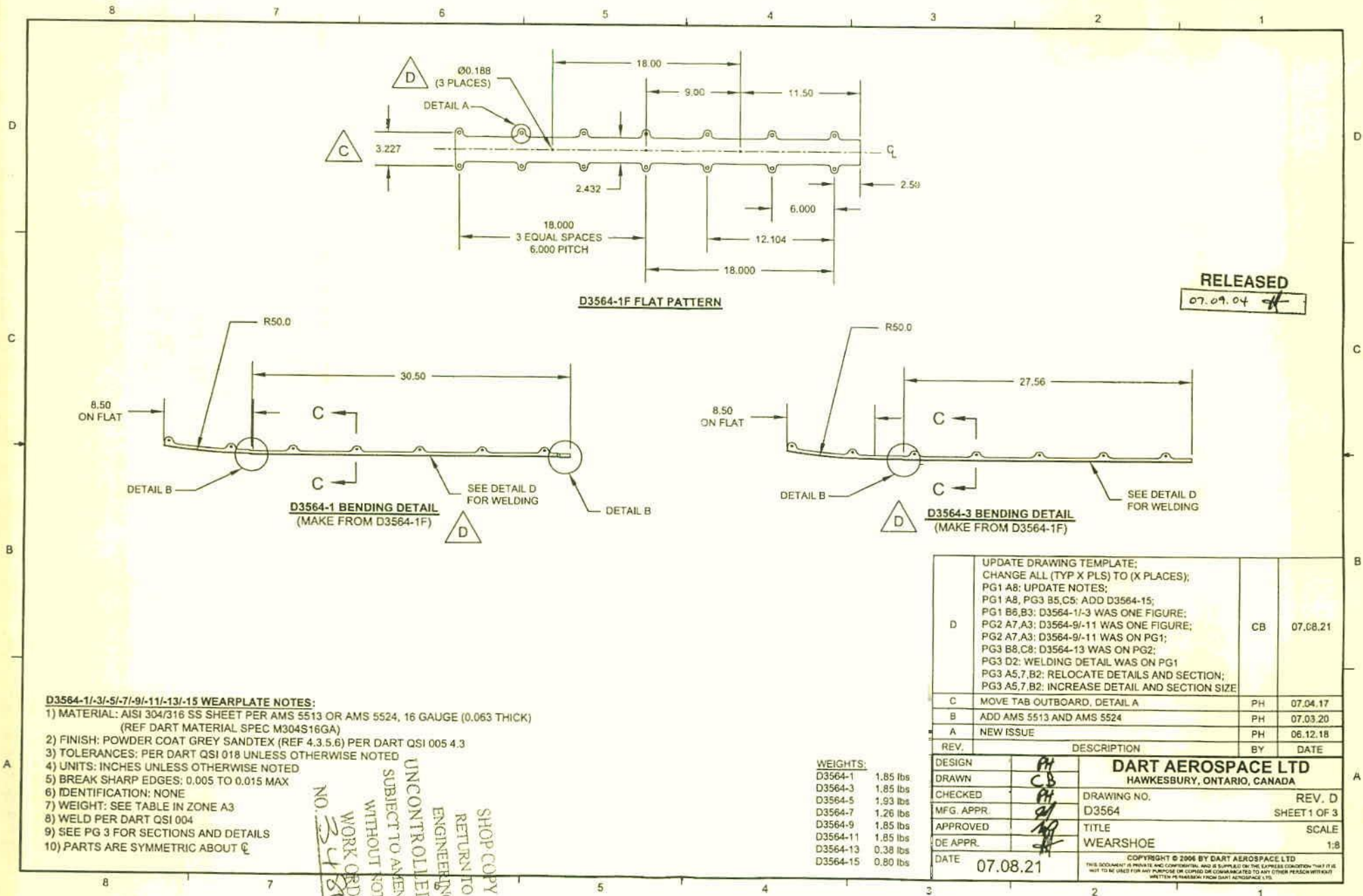
Comment: FINAL INSPECTION/W/O RELEASE

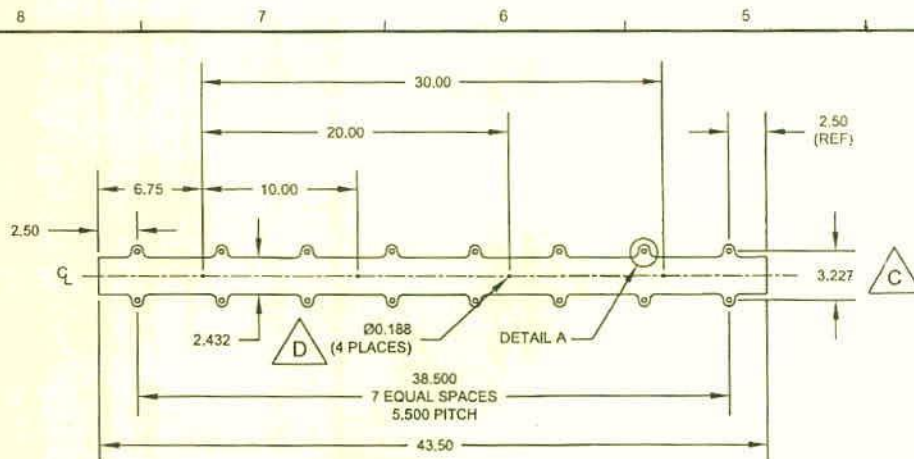
07/10/26 (10)

Job Completion

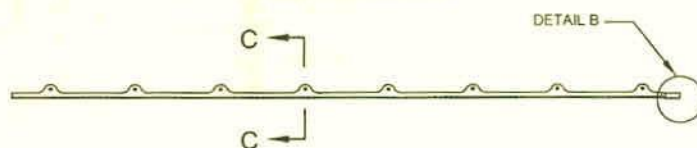


U 07-10-25

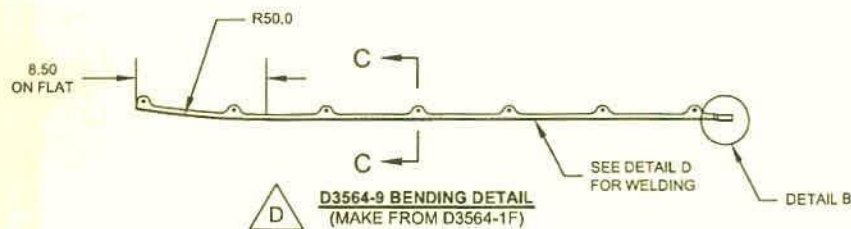




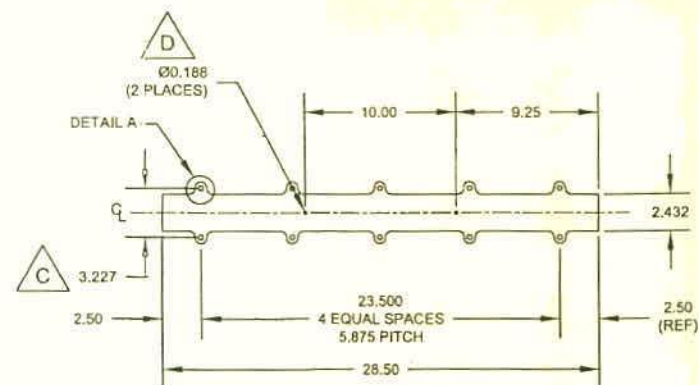
D3564-5F FLAT PATTERN



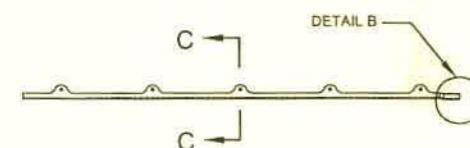
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



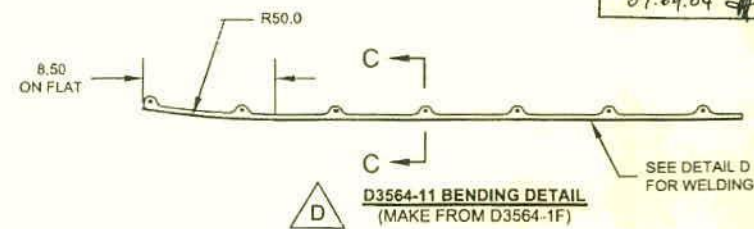
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



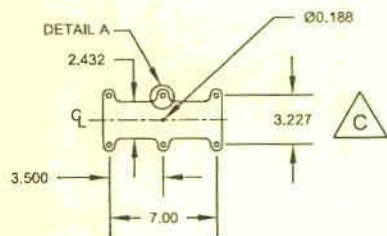
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

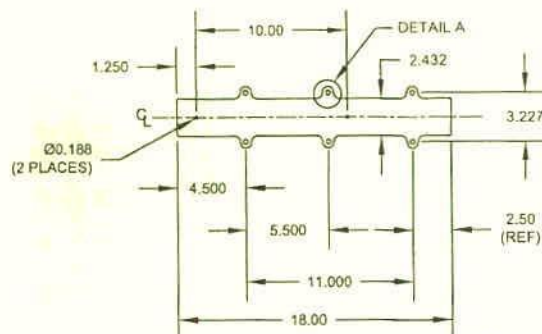
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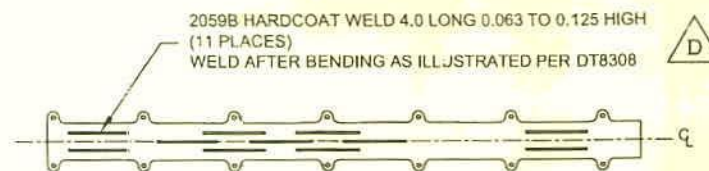
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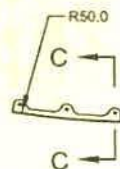
D3564-13F FLAT PATTERN



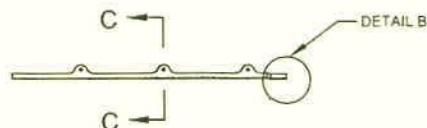
D3564-15F FLAT PATTERN



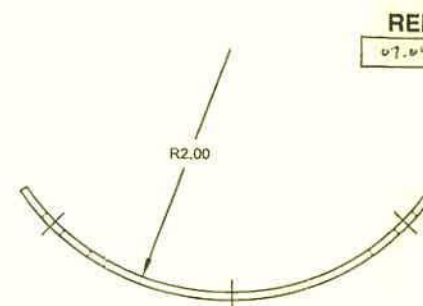
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



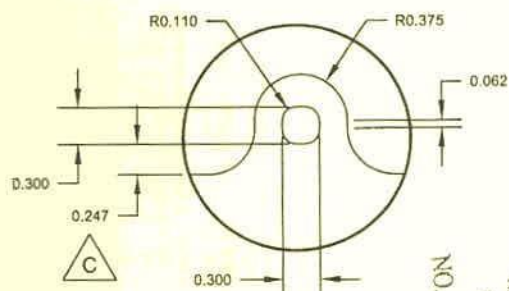
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



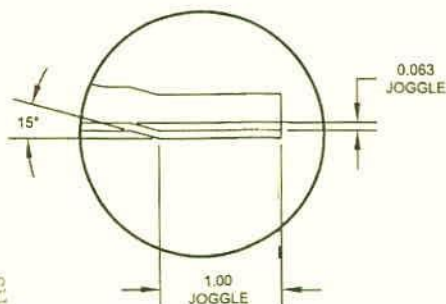
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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